

SHIP TODAY 10/08/09

# PRELIMINARY ISSUE

Work Order ID 61029

August 4, 2010 10:36:19 AM



Page 1

Item ID: D4078-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Clamp Half

Start Date: 04/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 08/08/2010 Req'd Qty: 2.00



Customer:



Reference: 10.08.09.

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4078	PA1

100

0.00



Bandsaw

Memo

0.00

8.8 10/08/08

2 6

Jeaspa Bandsaw

Cut blank 2.700" long

110

0.00



HAAS 1

Memo

0.00

8.8 10/08/08

2 1

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev: FBT AA

Dwg Rev: PBI

Deburr

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4078-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: *J* Date: 1008-10  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 61029		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/08/08	110	Radius of .480 was change for Radius .380 <sup>+.01</sup> <sub>-.00</sub> But Program was not modified R.C. Program C.R.R.R. 2 New Prog. Not Panel.	<i>J</i> <i>BSLun</i>	Scrap Replace Batch <u>110001</u>	<i>S</i> 10/08/09 10/08/09	<i>S</i> 10/08/09	<i>J</i> 10/08/09	<i>J</i> 10/08/09

NOTE: Date & initial all entries

**Work Order ID 61029**

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Start Date: 04/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 08/08/2010 Req'd Qty: 2.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

88,0/08/09

2

1

Quality Control

130



QC

QC8- Inspect parts - second check

0.00

→ Inspectn to PB1  
dry only  
Swablog

Quality Control

Memo

0.00

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

M 10 08 09 (2)

## Work Order ID 61029



Page 3

August 4, 2010 10:36:19 AM

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Item Name: Clamp Half

Start Date: 04/08/2010 Start Qty: 2.00

Accept



Setup

Start



Required Date: 08/08/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



Powdercoat

Powder Coating

Operation  
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Memo

START: 11:30AM  
Temp: 320°F  
Fin: 12:00PMSet Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

10/08/09 SP 2x

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

Memo

0.00

10/08/09 SP 8x

**Work Order ID 61029**

Page 4

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Start Date: 04/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 08/08/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10/08/10 AUTH WRELEASED   DATE  

*MK*  
*(0-8-9)*

*DPL/BBL/MS*

# Picklist Print

Page 1

August 4, 2010 10:36:18 AM

Work Order ID: 61029



Parent Item: D4078-1



Parent Item Name: Clamp Half

Start Date: 04/08/2010

Required Date: 08/08/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A, New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	14.3332	0.223	0.469474			

6061-T6 Bar 1.25 x 1.25



Location	Loc Qty	Loc Code
MAT03	14.33315053	
106259	7.06921053	
110001	7.26394	

4695 88 08/08/08

+ 2347 scrap parts

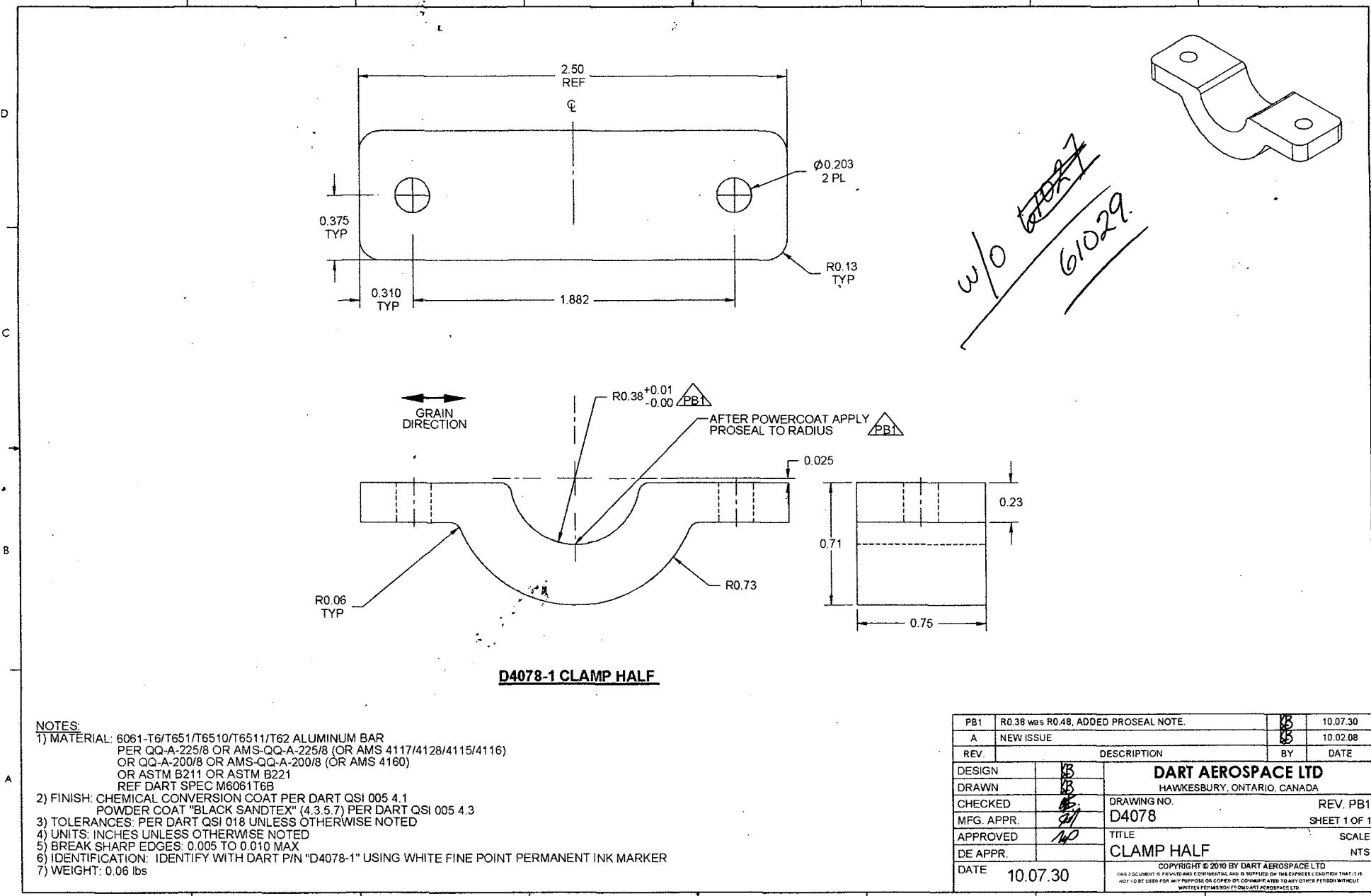
DART AEROSPACE LTD	Work Order:	61029
Description: clamp half	Part Number:	J4078-1
Inspection Dwg: J4078 Rev: DB1		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

Measured by:	<i>S.B.</i>	Audited by:	<i>S</i>	Preliminary Approval:	
Date:	<i>10/08/09</i>	Date:	<i>10/08/09</i>	Date:	

Rev	Date	Change	to PB Day only	Revised by	Approved
E	10.04.14	Added preliminary approval		KJ	

8 7 6 5 4 3 2 1



PB1	R0.38 was R0.48, ADDED PROSEAL NOTE.	BB	10.07.30
A	NEW ISSUE	BB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	BB	DART AEROSPACE LTD	
DRAWN	BB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BB	DRAWING NO.	REV. PB1
MFG. APPR.	BB	D4078	SHEET 1 OF 1
APPROVED	BB	TITLE	SCALE
DE APPR.		CLAMP HALF	NTS
DATE	10.07.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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## Kim Johnston

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** Wednesday, August 11, 2010 6:46 PM  
**To:** 'Kim Johnston'  
**Subject:** RE: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Yes ... They will be scrapped afterwards or used for Show purposes.

David

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]  
Sent: Tuesday, August 10, 2010 9:02 AM  
To: David Shepherd  
Subject: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Hi David,

I have two prelim work orders, D4079-1 B61027 and D4078-1 B61029. Mike tells me that they were sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after. I'll attach your email to the work orders and file them. Thanks,

Kim Johnston  
Dart Aerospace Ltd.  
Engineering Clerk  
Document Control  
1270 Aberdeen Street  
Hawkesbury, Ontario, K6A 1K7  
Email: kjohnston@dartaero.com  
Tel: 613-632-5200  
Fax: 613-632-9311

No virus found in this incoming message.  
Checked by AVG - www.avg.com  
Version: 8.5.441 / Virus Database: 271.1.1/3061 - Release Date: 08/09/10 18:35:00